

HAI

Work Order ID 65604

January 20, 2011 10:58:25 AM



Page 1

Item ID:	D4058-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ski Assembly, Fwd RH					
Start Date:	1/20/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/27/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/01/20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4058	A								
100		0.00							
	HandThermo								
Hand Finishing Thermoforming	Memo Pick Kit	0.00							
110		0.00							
	HandThermo								
Hand Finishing Thermoforming	Memo 1- Assemble as per Dwg D4058-042 2- install wearplates 3- Use wearbar to locate & transfer drill mounting holes as per dwg. 4- Install werbars as per dwg.	0.00							

OK
11/02/04
PTC →

Cancelled

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/02/04	100	w/o calls for AN4C5A x13 bolts should read. AN3C5A x13. corrected Bona	DL	11/02/04			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65604

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Page 2

Item ID: D4058-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Assembly, Fwd RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF 11-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 20, 2011 10:58:24 AM

Work Order ID: 65604

Parent Item: D4058-042



Parent Item Name: Ski Assembly, Fwd RH

Start Date: 1/20/11**Required Date:** 1/27/11

Start Qty: 1.00

Required Qty: 1.00

Comments: New Issue 10/03/16 Rev. A DL verified by:DD
10/04/05 DL Added Wearbars & assoc. hardware.

IPP Rev. B

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/02/04							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 65604

Parent Item: D4058-042

Parent Item Name: Ski Assembly, Fwd RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

D4015-041

Manufactured No

100

Each

44.0000

13

13



Wearbar Weldment

*Returned to Stock
Sh.
11/02/08*

Location

ST114

Loc Qty

44

Loc Code

44

D4058-2

Manufactured No

100

Each

0.0000

1

1



Ski Section, Fwd RH

Cancelled. Batch 65598

D4067-041

Manufactured No

100

Each

7.0000

5

5 ✓



Joggled Wearplate

*Returned to Stock
Sh 11/02/08*

Location

therm

Loc Qty

7

Loc Code

7

D4069-1

Manufactured No

100

Each

0.0000

6

6



Spacer

MS21043-3

Purchased No

100

Each

1,677.000

13

13



Nut

Location

FG

Loc Qty

76

Loc Code

103691

76

ST301

1601

112314

1601

13

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 10:58:25 AM

Work Order ID: 65604

Parent Item: D4058-042

Parent Item Name: Ski Assembly, Fwd RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No 100 Each 1,194.000 20 20



Nut



DL
4/02/02

Returned to Stock
DL 11/02/08

Location

Loc Qty

Loc Code

ST301

1194

114523

5

114784

2

~~115936~~

291

116188

596

116549

300

DL

NAS1149C0432R

Purchased

No

100

Each

204.0000

20

20



Washer



DL
4/02/07

Returned to Stock
DL 11/02/08

Location

Loc Qty

Loc Code

ST297

204

114292

50

114742

63

116304

91

4116005

DL

NAS1149C0463R

Purchased

No

100

Each

166.0000

20

20



Washer



Location

Loc Qty

Loc Code

ST297

166

112314

8

115358

158

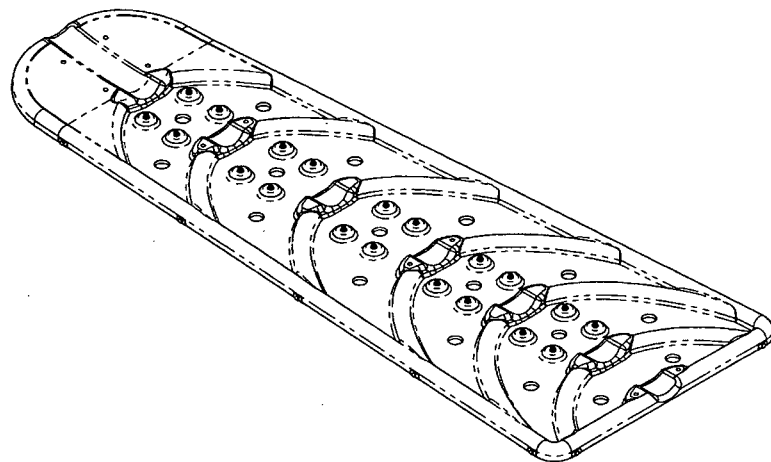
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

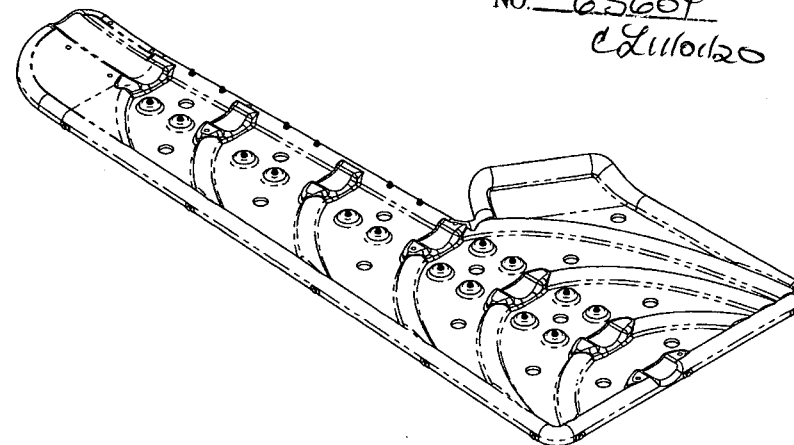
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4058-041 FWD SKI ASSY, LH



D4058-042 FWD SKI ASSY, RH

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NO. 65609
CL110120

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2010-04-07
MB

A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4058 TITLE FWD SKI ASSY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A	SHEET 1 OF 6
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.31		

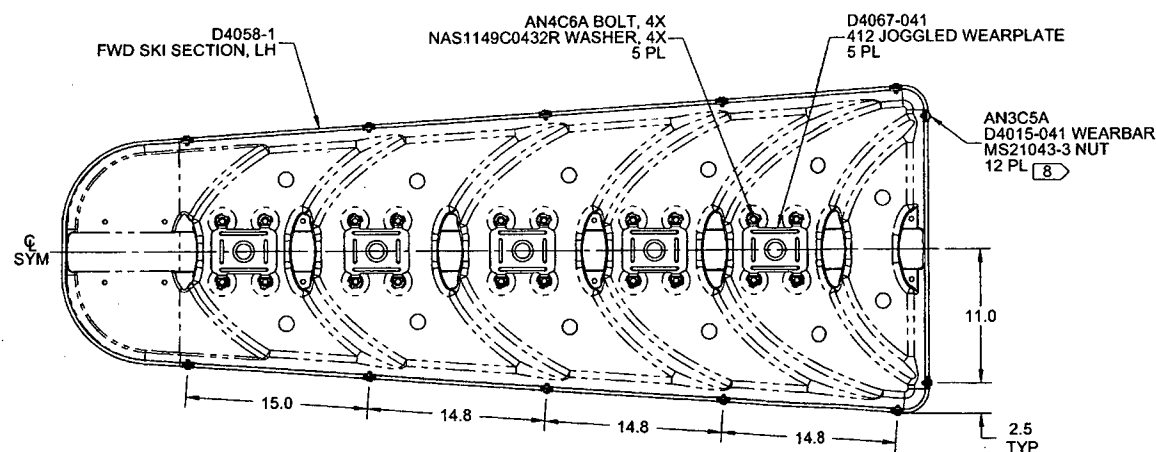
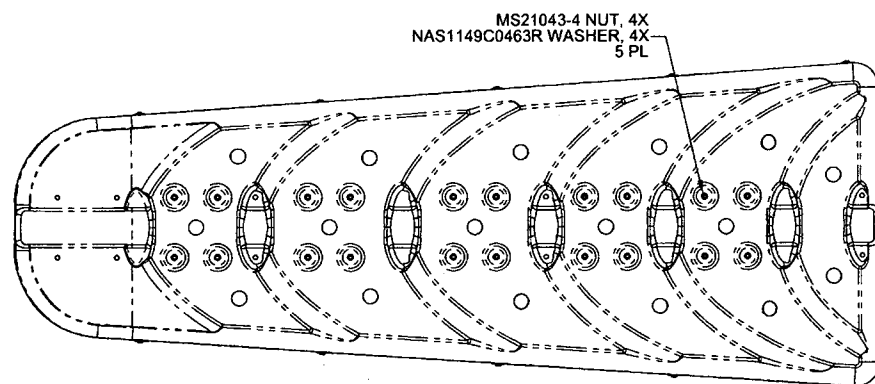
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4058-041 FWD SKI ASSY, LH

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4058-041	FWD SKI ASSY, LH
2	12	D4015-041	WEARBAR
3	1	D4058-1	FWD SKI SECTION, LH
4	5	D4067-041	412 JOGGLED WEARPLATE
5	12	AN3C5A	
6	20	AN4C6A	BOLT
7	12	MS21043-3	NUT
8	20	MS21043-4	NUT
9	20	NAS1149C0432R	WASHER
10	20	NAS1149C0463R	WASHER

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WORK ORDER
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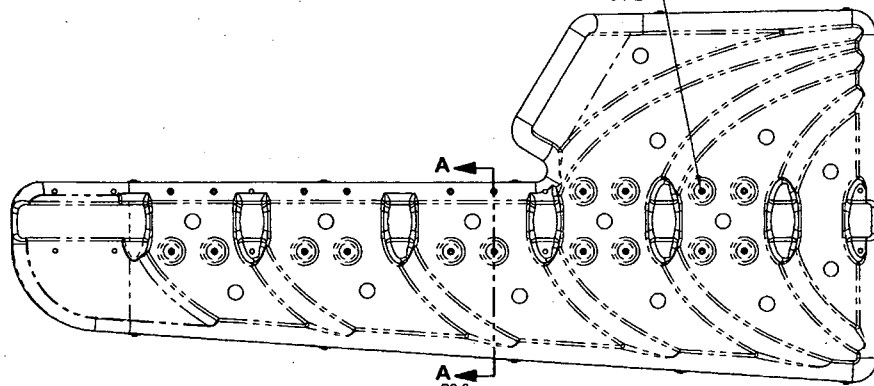
RELEASED
2010-04-07
JMP

D4058-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.5 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL $\phi 0.191$ " HOLE FROM D4015-041 TO D4058-1.
CHAMFER HOLE 0.03 X 45°.
FASTEN USING PRESCRIBED HARDWARE
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

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MFG. APPR.			SHEET 2 OF 6
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DE APPR.			NTS
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NAS1149C0463R WASHER, 4X
MS21043-4 NUT, 4X
5 PL



D4058-2
FWD SKI SECTION, RH

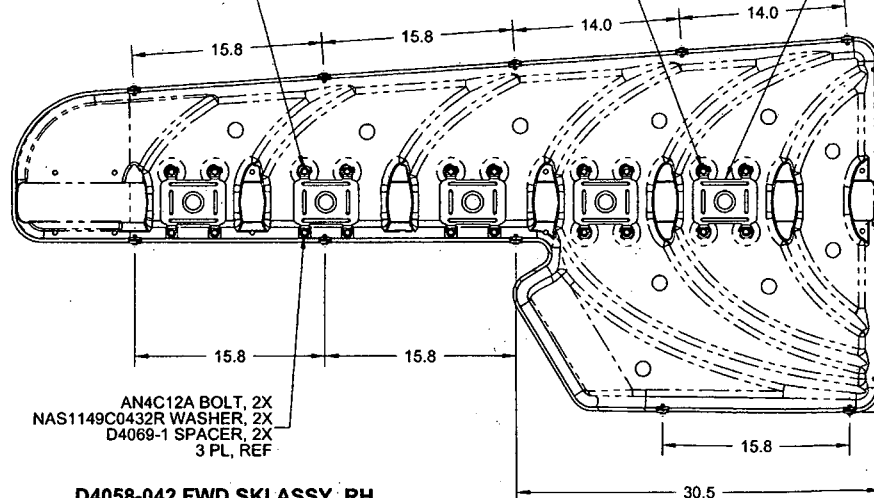


AN4C6A BOLT, 2X
NAS1149C0432R WASHER, 2X
3 PL, REF

AN4C6A BOLT, 4X
NAS1149C0432R WASHER, 4X
2 PL

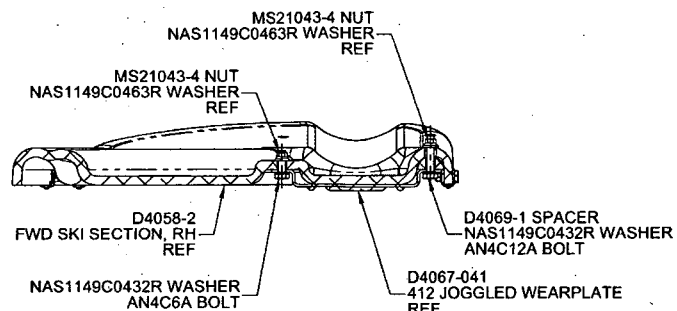
D4067-041
412 JOGGLED WEARPLATE
5 PL

AN3C5A
D4015-041 WEARBAR
MS21043-3 NUT
13 PL



AN4C12A BOLT, 2X
NAS1149C0432R WASHER, 2X
D4069-1 SPACER, 2X
3 PL, REF

D4058-042 FWD SKI ASSY, RH



ITEM	QTY	P/N	DESCRIPTION
1	X	D4058-042	FWD SKI ASSY, RH
2	13	D4015-041	WEARBAR
3	1	D4058-2	FWD SKI SECTION, RH
4	5	D4067-041	412 JOGGLED WEARPLATE
5	6	D4069-1	SPACER
6	14	AN4C6A	BOLT
7	13	MS21043-3	NUT
8	20	MS21043-4	NUT
9	13	AN3C5A	
10	6	AN4C12A	BOLT
11	20	NAS1149C0432R	WASHER
12	20	NAS1149C0463R	WASHER

SECTION A-A C6-3
ROTATED 90° CW, SCALED 4X
6 PL

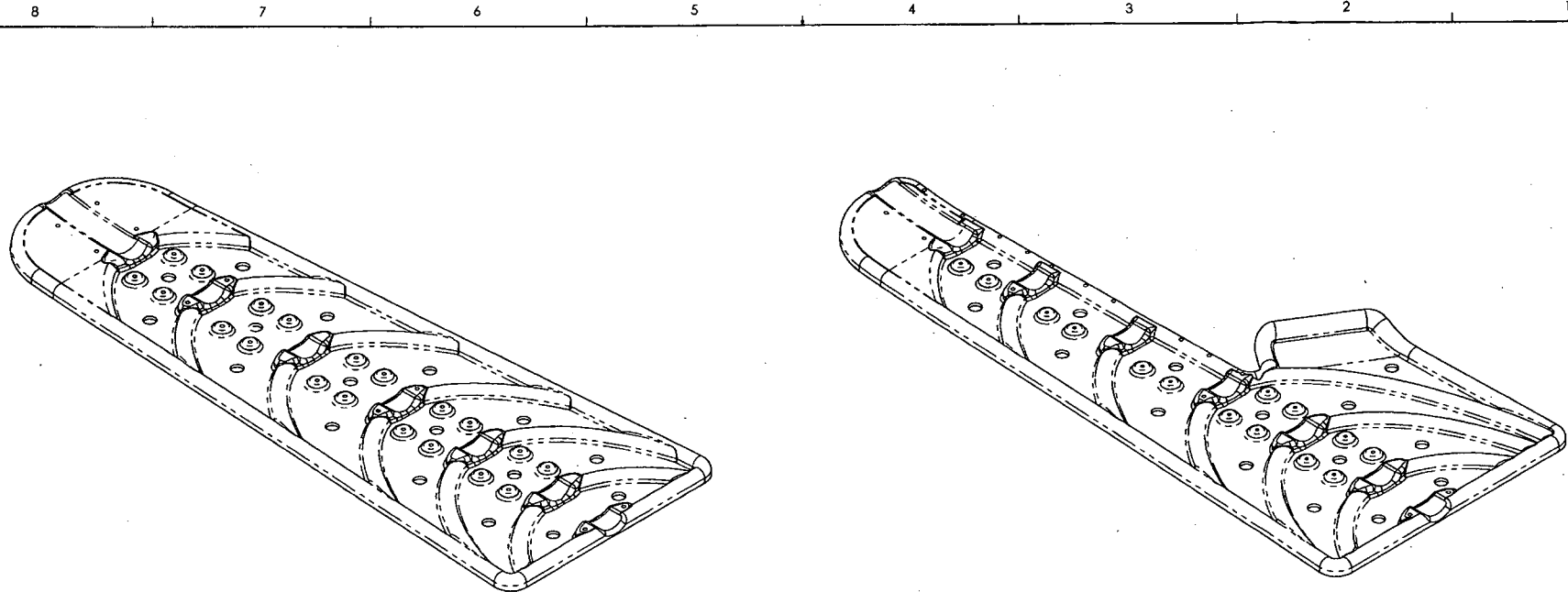
- D4058-042 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 23.5 lbs
 - 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4058-2.
CHAMFER HOLE 0.03 X 45°.
FASTEN USING PRESCRIBED HARDWARE
 - 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

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2.5
TYP

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D4058-1 FWD SKI SECTION, LH

D4058-2 FWD SKI SECTION, RH

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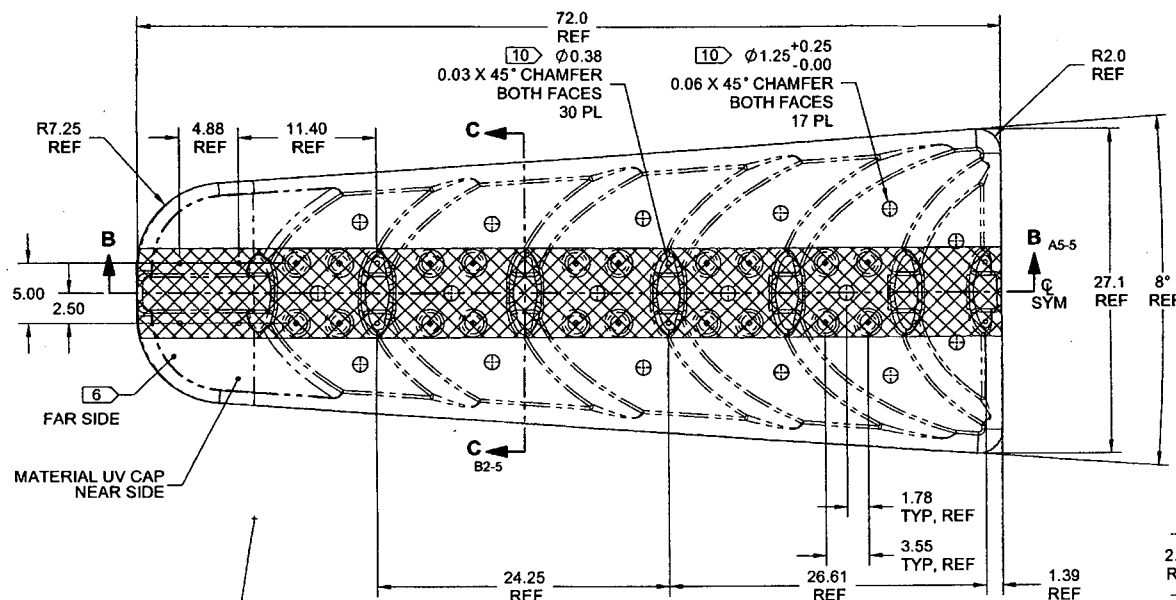
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D4058-1/2 NOTES:

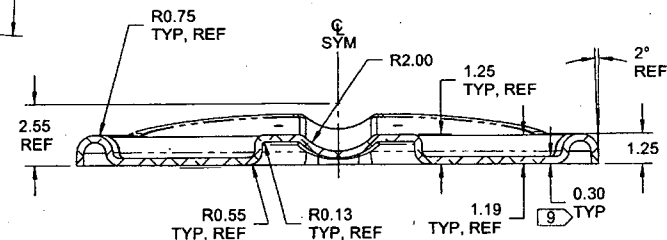
- 1) MATERIAL: ALEXTRA ET SHEET, 0.300 THICK
REF. DART SPEC. M-ALXTRAB.300
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4058-X" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: D4058-1 = 24.35 lbs, D4058-2 = 22.25 lbs
- 8) THERMOFORMING: PER DT9599 (D4058-1) OR DT9600 (D4058-2) AND DART QSI 022
- 9) MINIMUM THICKNESS: IN SHADED AREA = 0.210
OUTSIDE SHADED AREA = 0.175
- 10) PICK UP ON EXISTING MOLD MARKINGS AND DRILL THRU AS SHOWN

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DE APPR.			NTS
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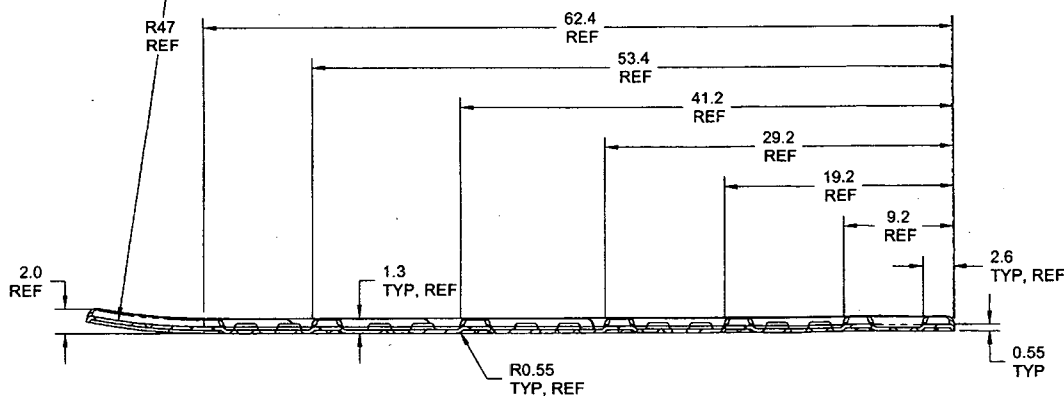
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D4058-1 FWD SKI SECTION, LH
THERMOFORM PER DT9599 AND QSI 022



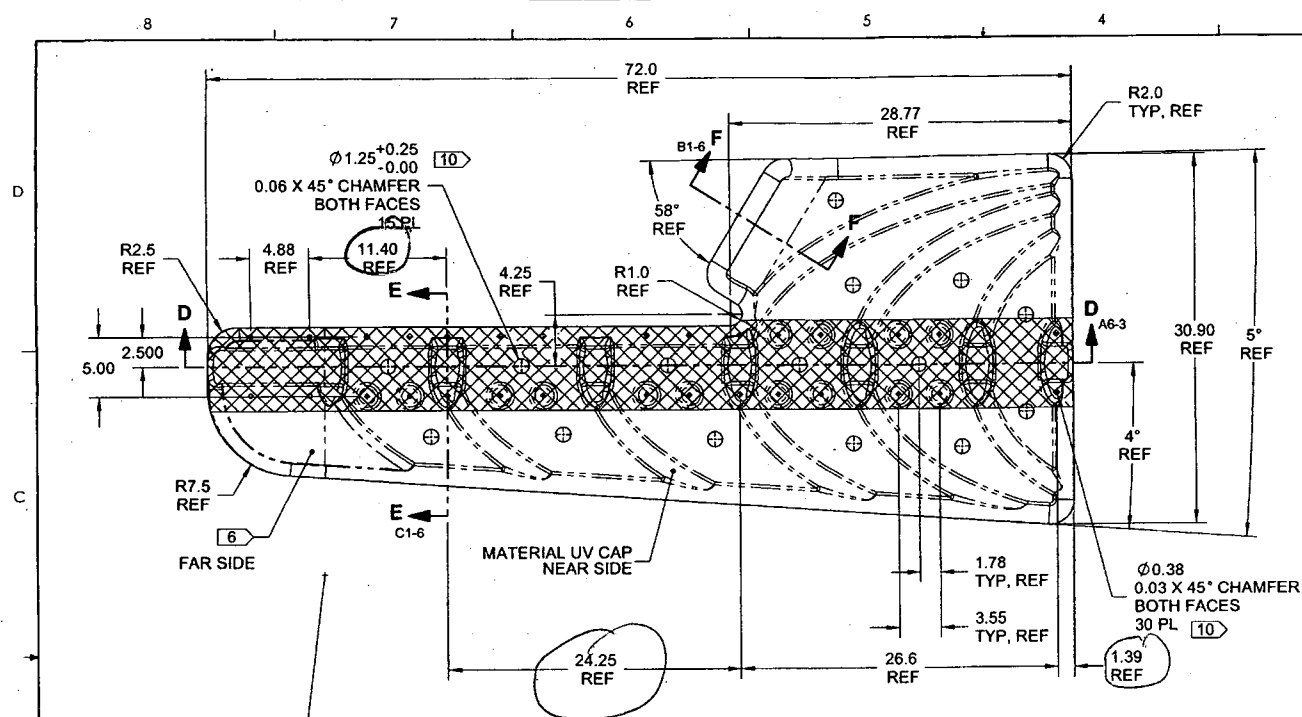
SECTION C-C
SCALE 2X C6-5



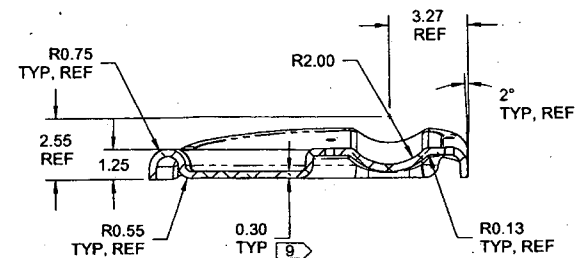
SECTION B-B
D4-5

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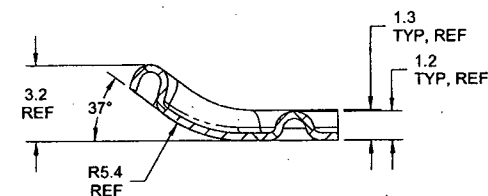
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MFG. APPR.		TITLE	SHEET 5 OF 6
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D4058-2 FWD SKI SECTION, RH
THERMOFORM PER DT9600 AND QSI 022



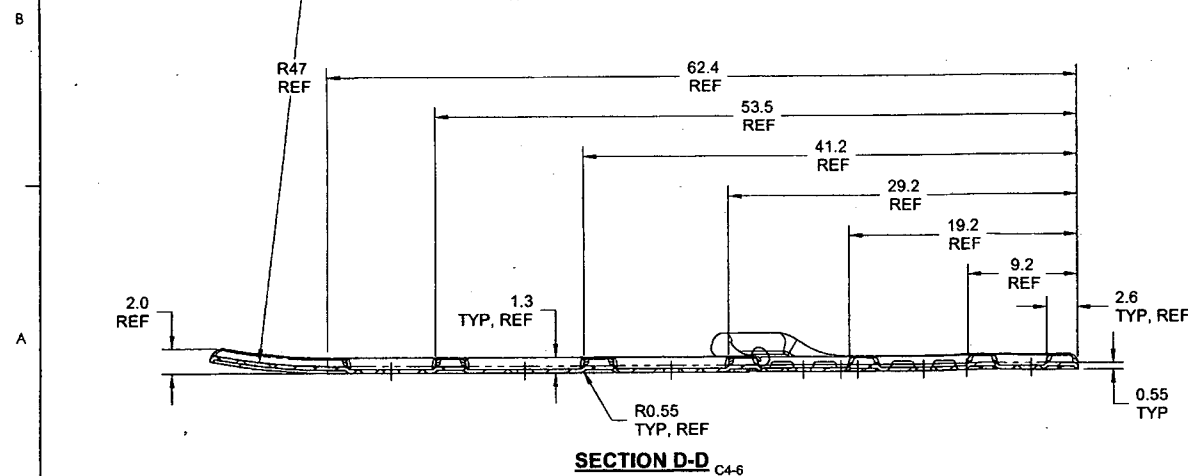
SECTION E-E
B1-6
ROTATED 90° CW



SECTION F-F
C7-6
ROTATED 32° CCW

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2010-04-07



SECTION D-D
C4-6

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CHECKED		DRAWING NO. D4058	REV. A
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